

CLAIMS

1. A method for manufacturing knitted articles for forming items of clothing, such as body suits, sleeveless tops, undershirts, bras, underpants or the like, without lateral seams, with a circular knitting machine, characterized in that it comprises at least one step for forming tabs (1a,1b,1c,1d,2a,2b,2c,2d,3a,3b), in which exclusively all or some of the needles that belong to a sector of the needle cylinder are moved so as to knit at at least one feed or drop of the machine, and the needle cylinder of the machine is actuated with an alternating rotary motion about its own axis, with an extent of oscillation that is sufficient to produce the transit, at said at least one feed, of all the needles of said at least one sector that are moved to knit at said at least one feed, in order to make the needles of said at least one sector that are moved to knit at said at least one feed form a preset number of rows of knitting.

2. The method according to claim 1, characterized in that said step for forming tabs (1a,1b,1c,1d,2a,2b,2c,2d,3a,3b) is followed or preceded by at least one step for forming a tubular portion of knitting (11,12,21,22,24,25), in which needles distributed along the entire circumferential extension of the needle cylinder of the machine are moved to knit at at least one feed or drop of the machine.

3. The method according to claims 1 and 2, characterized in that said step for forming a tubular portion of knitting (11,12,21,22,24,25) is performed by actuating the needle cylinder with a continuous rotary motion about its own axis.

4. The method according to one or more of the preceding claims, characterized in that during said tab forming step a preset number of needles located proximate to the ends of said sector is actuated at said at least one feed with a selection with needles in a one-to-one inactive configuration.

5. The method according to one or more of the preceding claims, characterized in that during said tab forming step a preset number of needles

located proximate to the ends of said sector is actuated at said at least one feed with a selection with needles in a one-to-one tuck-stitch position.

6. The method according to one or more of the preceding claims, characterized in that the number of needles of said sector that are moved to  
5 knit at said at least one feed is changed according to a preset program.

7. The method for producing knitted articles for forming items of clothing (10,20) with shoulder straps, according to one or more of the preceding claims, wherein said tabs (1a,1b,1c,1d,2a,2b,2c,2d,3a,3b) constitute the shoulder straps of the item of clothing (10,20), characterized  
10 in that it comprises:

- a step for forming the shoulder straps (1a÷1d,2a÷2d), in which needles that belong to four sectors of the needle cylinder that are angularly spaced from each other around the needle cylinder axis are moved to knit at a different feed for each one of said sectors,  
15 and the needle cylinder is actuated with an alternating rotary motion about its own axis with an extent of oscillation that is such as to produce the transit, in front of the corresponding feed, of all the needles of the correlated sector that are moved to knit;
- a step for forming the remaining part of the article (10,20), which  
20 comprises at least one step for forming at least one tubular portion of knitting (11,12,21,22) by moving so as to knit, at at least one feed or drop of the machine, all or some of the needles of the needle cylinder that are distributed along the entire circumferential extension of the needle cylinder, and the needle cylinder is  
25 actuated with a continuous rotary motion about its own axis.

8. A method for producing knitted articles for providing items of clothing such as underpants (30) or the like, according to one or more of the preceding claims, wherein said tabs (3a,3b) constitute the front and rear regions of the underpants (30) arranged between the leg cuts, characterized  
30 in that it comprises:

- 5 -- a step for forming the front and rear region of the underpants (30),  
in which needles that belong to two sectors of the needle cylinder  
that are angularly spaced from each other around the needle  
cylinder axis are moved to knit at a different feed for each one of  
said sectors, and the needle cylinder is actuated with an alternating  
rotary motion about its own axis with an extent of oscillation that  
is such as to produce the transit, in front of the corresponding feed,  
of all the needles of the correlated sector that are moved to knit;
- 10 -- a step for forming the remaining part of the article, which  
comprises at least one step for forming at least one tubular portion  
(31) of knitting by moving so as to knit, at at least one feed or drop  
of the machine, all or some of the needles of the needle cylinder  
that are distributed along the entire circumferential extension of  
the needle cylinder, and the needle cylinder is actuated with a  
15 continuous rotary motion about its own axis.

9. The method according to one or more of the preceding claims,  
characterized in that said step for forming the remaining part of the article  
(20) comprises a step for forming pocket-like regions (25a,25b), in which  
some or all of the needles that belong to at least one sector of the needle  
20 cylinder are moved to knit at at least one feed of the machine, actuating the  
needle cylinder of the machine with an alternating motion about its own  
axis, with an extent of oscillation that is sufficient to produce the transit, at  
said at least one feed, of all the needles of said at least one sector that are  
moved to knit at said at least one feed, in order to form, with the needles  
25 that belong to said at least one sector, a number of rows of knitting in excess  
with respect to the number of rows of knitting formed by the needles that do  
not belong to said sector.

10. The method according to one or more of the preceding claims,  
characterized in that during said step for forming pocket-like regions  
30 (25a,25b) some rows of knitting are also formed by moving to knit, at said

at least one feed, some or all of the needles distributed along the entire circumferential extension of the needle cylinder.

11. The method according to one or more of the preceding claims, characterized in that during said step for forming pocket-like regions  
5 (25a,25b) the number of needles that belong to said sector and are moved to knit at the corresponding feed is increased gradually.

12. The method according to one or more of the preceding claims, characterized in that during said step for forming pocket-like regions (25a,25b) the number of needles that belong to said sector and are moved to  
10 knit at the corresponding feed is decreased gradually.

13. The method according to one or more of the preceding claims, characterized in that it comprises the forming of a double folded knitting completion border.